## Work Order ID 102572

June-03-13 9:20:29 AM

Large Fab

\*102572\*

Page 1

Item ID: D3053-042 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: 212 Basket Base Assembly Start Date: \*1\* 6/03/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 6/10/13 Rea'd Oty: 1.00 **Customer:** Reference: Run Process Plan: MLJ Date: 13 06-03 Tooling: **Approvals:** Date: Stop QC: \_\_\_\_ Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Otv Number Stamp **Draw Nbr Revision Nbr** D3053 Rev B 100 0.00 Large Fab CC 13-6-11 \*100\* Large Fab 0.00 Memo Large Fab 1-Cut 5 D2235-3 FROM D3166-1 using DT8365 2-Cut Ribs from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing as per dwg. 3-Remove all markings from material 4-Drill holes in D3053-3 as per dwg D3053 5-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995 6- Cut mesh as per dwg Weld per dwg A/R S.S. rod Batch: B/23823 110 Large Fab CC 13-6-11 \*110\* Large Fab 0.00 Memo

1 -Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as

required

DQA:			Date:				_						<b>W</b>	<b>DART</b>
QA Closed:			Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / U		Work Order ເ	pdate only	· 	A E R O S P.A C E
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Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	iption	Date	Verificatio	n	QC Inspector
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June-03-13 9:20:29 AM

Page 2

Item ID: D3053-042 Accept Revision ID: Item Name: 212 Basket Base Assembly Start Date: 6/03/13 Start Otv: 1.00 \*1\* Required Date: 6/10/13 Reg'd Otv: 1.00 Reference: Process Plan: \_\_\_\_ Date: Tooling: Approvals: QC: \_\_\_ Date: SPC (Y/N): Sequence ID/ Operation Set Up/ Work Center ID Description **Run Hours** 120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 \*120\* 0.00 Memo Quality Control 130 QC6- Inspect dimensions to drawing 0.00 \*130\* QC 0.00 Memo Quality Control 150 White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel \*150\* Powdercoat Powder Coating START TIME: OVEN TEMPERATURE: M125620 FINISH TIME: 2nd cont Stunt Time, 11:00 Temp : 4000F Finish Time: 11:30

\*N900040100\* Cust Item ID: **Customer:** Run Date: Date: Tool ID Tool # Plan Accept Reject Reject Insp. Code Oty **Q**ty Number Stamp 13-06-12 DAS

Setup Start

1X/m/13/06/13

DQA:	Date:									DART		
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NCR N	۱o				Suspected Unapproved			Large Fab	Composite		Supplier	
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		/Kink/Rippl	e/Wave		Burrs	<u> </u>	1	ion Incomplete/Und		Part Lost/M	· -	Weld
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	Heat Treat			<u> </u>	Cut Too Short	L	Mislabe		. L	Power Loss,	/Surge	Other
	Inspection Strip in Tube			<u> </u>	Drawing	<u> </u>	Misrea					
		/Chatter		-	Drill Holes	Off-set						
		ng Sequence		<u> </u>	Finish	<u> </u>	4	Calibration				
	Wave/Twist in Tube				Fit/Function		Out of	Sequence				

## Work Order ID 102572

June-03-13 9:20:29 AM

\*102572\*

Page 3

Item ID: D3053-042 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: 212 Basket Base Assembly **Start Date:** 6/03/13 Start Qty: 1.00 Cust Item ID: Required Date: 6/10/13 Reg'd Otv: 1.00 **Customer:** Reference: Run **Approvals:** Process Plan: Date: Tooling: Date: QC: \_\_\_\_ Date:\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Reject Tool # Plan Accept Insp. Reject **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 160 QC3- Inspect Part Finish 0.00 \*160\* Memo 0.00 Quality Control Identify as per dwg & Stock Location: D205- 500 1-043. 170 \*170\* Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 \*120\* 0.00 Memo Quality Control

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DQA:		_ Date:			WORK ORDER NON	c	NIEOI	DNAANCE / II	DDATE				<b>?T</b>
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Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspect	tor
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Landii	Cracks Crimp/K Cuffs Crushing Heat Tre Inspectic	Not Concer ink/Ripple S eat on Strip in	e/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Ui ions Incomplete/U ned/off center iled		Outside Din Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss,	tolerance ct issing Wrong	Pressure/Forced Set-up Temperature/C Weld Wrong Stock Pu Other	ure
ŀ				-	Fit/Function		l	Lalibration Sequence		<del></del>			
	Wave/Twist in Tube				1	1 !	1	requerior					

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## **Picklist Print**

June-03-13 9:20:33 AM

Work Order ID: 102572

\*102572\*

Parent Item:

D3053-042

\*D3053-042\*

Parent Item Name: 212 Basket Base Assembly

**Start Date:** 6/03/13

Required Date: 6/10/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ/RF IPP Rev:D 08-08-29 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-1		Manufactured	No			100	Each	1.0000	5	5			
*D3166-1* Basket Hoop									**	-	[ ]	3-6-	
				Locatio	<u>1</u>	Loc (	Oty 0	Loc Code					
				WA006	0.000		189	8978		(5×)	<u> </u>		
M304EX0.75-16F		Purchased	No		86807	100	l sf	1 165 015	48	50.50	-		
*M304FX0	75 16		110			100	51	1,165.915	**	50.52632			, ,,
IVI.3(14日人) Expanded Metal Flat SS	/ n- inf	•							. —		_CC_	13-0	0-10
•				Location	!	Loc C	<u>Qty</u>	Loc Code					
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•					125113	176.279			_		_		
				WA	125457		414		_	FM C	7		
				WA007	125457		414			50.5	L		
				WA007	123448	575	.636 5.96	•	_		-		
					125457		.676				- *		
					125605		480		_		-		
/304TS0.750W.065		Purchased	No			100	f	1,901.904	43.3333	45.614	-		
*M304TS0 804 SQ Tube .75x.75x.065W	750W	065*			•				**		. /3	-6-10	<b>5</b>
23303				Location		Loc (	<u>Oty</u>	Loc Code					
23 500				MAT017		1228	8.02						
				(	123303		8.02			45.6	14		
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	Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced		
[	Centre Not Concentric				BOM/Route		Grain			Over/Under	tolerance	Set-up		
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	et 🗀	Temperature/Cure		
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved	:	Wrong Stock Pulled		
	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_		
	Heat Trea				Cut Too Short		Mislabe	eled	L	Power Loss/	Surge	Other		
		n Strip in	Tube		Drawing	Misread								
	Marks/Cl			-	Drill Holes	Off-set								
	Turning Sequence				Finish	Out of Calibration								
	Wave/Twist in Tube				Fit/Function	1	Out of 9	Sequence						

June-03-13 9:20:33 AM

Work Order ID: 102572

\*102572\*

Parent Item:

D3053-042

Parent Item Name: 212 Basket Base Assembly

\*D3053-042\*

97261

75581 98040 98473

**Start Date:** 6/03/13

Required Date: 6/10/13

Start Qty: 1.00

\*\*

Required Qty: 1.00

D2232-3

\*D2232-3\*

Basket Hinge

Manufactured

110

Each

28

20

Each

31.0000

Loc Code

2

CC 13-6-11

Location WA WA004

Manufactured No

Loc Qty 110

\*\*

B10/800 -2x CC 13-6-6

Spacer Bushing

D2327-3

Location Loc Qty Loc Code WA004 79 100523 41

101800 75564 77229 81144 89384

98701

2 1

31

79.0000

DQA:		_ Date:										<b>Δ</b> Ω	RT
QA Closed:		Date:			WORK ORDER NON	AERO	SPACE						
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raiti					Use-as-is	Thermoforming Finishing				<del></del> 1	re/Packaging	Othe	`-
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Doc/Data													
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Handling/Pre		İ									1		
Material													
Operator					•								
Offset/Setup				:		1							
Process			}								į		
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Training			İ										
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Landi	ng Gear				General		-		<u></u>			<del></del>	
	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Ford	ced
	Centre I	Not Conce	ntric		BOM/Route		Grain		Ĺ	Over/Under	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature,	/Cure
	Crimp/k	ink/Ripple	/Wave	<u> </u>	Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/l	Jnclear	Part Moved		Wrong Stock	Pulled
	Crushin	-		<u> </u>	Countersink		Misalig	ned/off center		Positioned V	Vrong		
	Heat Tr	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge [	Other	
	Inspecti	on Strip in	Tube		Drawing		Misread	t					
	Marks/0	hatter			Drill Holes		Off-set					-	
		Sequence			Finish		Out of 0	Calibration					
Wave/Twist in Tube			Fit/Function		Out of Sequence								

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June-03-13 9:20:33 AM

Work Order ID: 102572

Parent Item: D3053-042 \*102572\*

\*D2581\* Mounting Bracket

Parent Item Name: 212 Basket Base Assembly

\*D3053-042\*

**Start Date:** 6/03/13

Required Date: 6/10/13

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured

110

Each

50.0000

CC 13-6-6

<u>Location</u>	Loc Qty	Loc Code
WA	2	
98503	. 2	
WA004	i 48	
(101383)	20	
70766	2	
81253	1	
82506	. 2	
83230	3	
85452	. 2	,
87706	2	
99067	10	
99837	6	

DQA:	,	_ Date:			WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE	V	ork Order u	odate only	$\neg$	AEROSPACE
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Work Orde	er:					1				7		—	[]
D					Rework			Skid-tube Crossti		_	Water Jet	4	Engineering
Part N	NO				Scrap .			Machining Small		-	d. Eng. Coor.	4	Quality
NCR 1	No.				Use-as-is Suspected Unapproved		Inerr	noforming Finish	·	Kec/Stol	re/Packaging	긕	Other
NCN	···		,		Suspected Onapproved	<u>[</u>		Large Fab Compos	site[	j	Supplier	ب	
Root				Desc	ription of work order update		Initial	Action		Sign &		$\neg$	
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	Bending				Bend	L	Folio/P	rogram		Outside Dim	ensions		Pressure/Forced
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	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	t [		Temperature/Cure
	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	Crushing				Countersink		1	ned/off center		Positioned V			
	Heat Trea				Cut Too Short	$\vdash$	Mislabe		L	Power Loss/	Surge		Other
	Inspectio		Tube		Drawing	_	Misread	1					<u> </u>
	Marks/Ch				Drill Holes	-	Off-set						
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	Turning Sequence Wave/Twist in Tube			1	Fit/Function	ı	Dut of S	Coguenco					

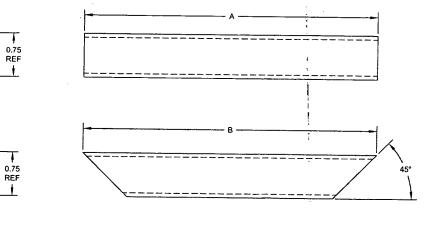
## PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2		96.00	RIB
D3053-3	2		25.50	RIB
D3053-5	6	23.73		RIB
D3053-7	3	25.31		RIB
D3053-9	3	19.48	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB

SHOP COPY RETURN TO ENGINEER G UNCONTROLL ( SUBJECT

V . . . . . . . . . E

WORK ORDER NO. 102572 MUJ 13-06-03





OTES: FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING			FRAME MATERIAL WAS 0.060 W UPDATED, DRAWING MOVED TO
REF. DART SPEC M304TS0.750W.065			UPDATED TO CURRENT STAND
MESH MATERIAL: 3/4-16F EXPANDED SS		Α	NEW ISSUE
REF DART SPEC M304EX0 75-16E	l or	F14	

3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: NONE

0.75 REF

0.065 REF

0.065 REF

8) WEIGHT: N/A

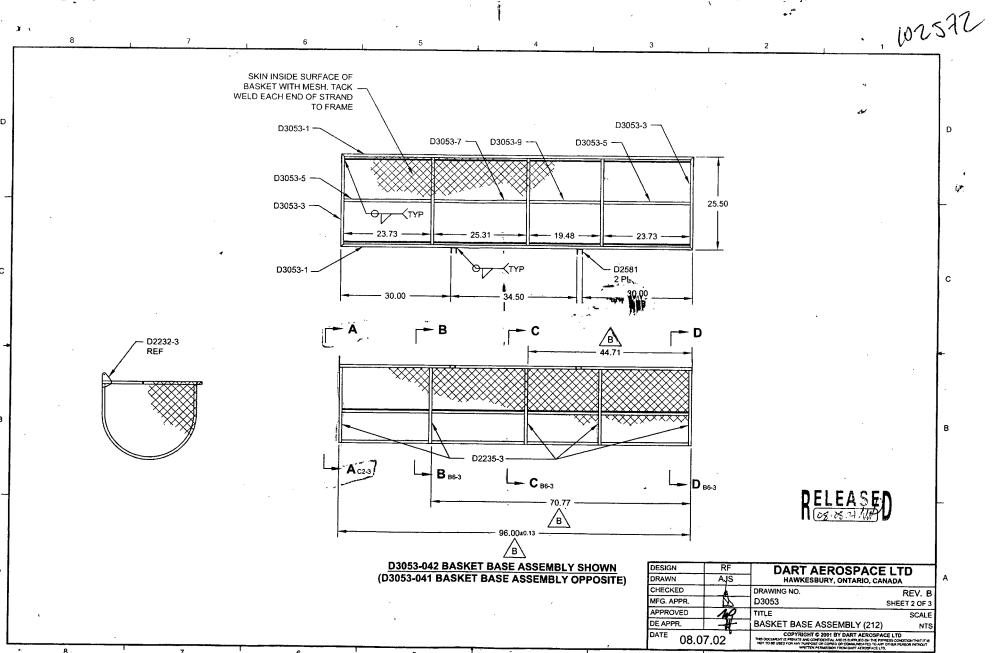
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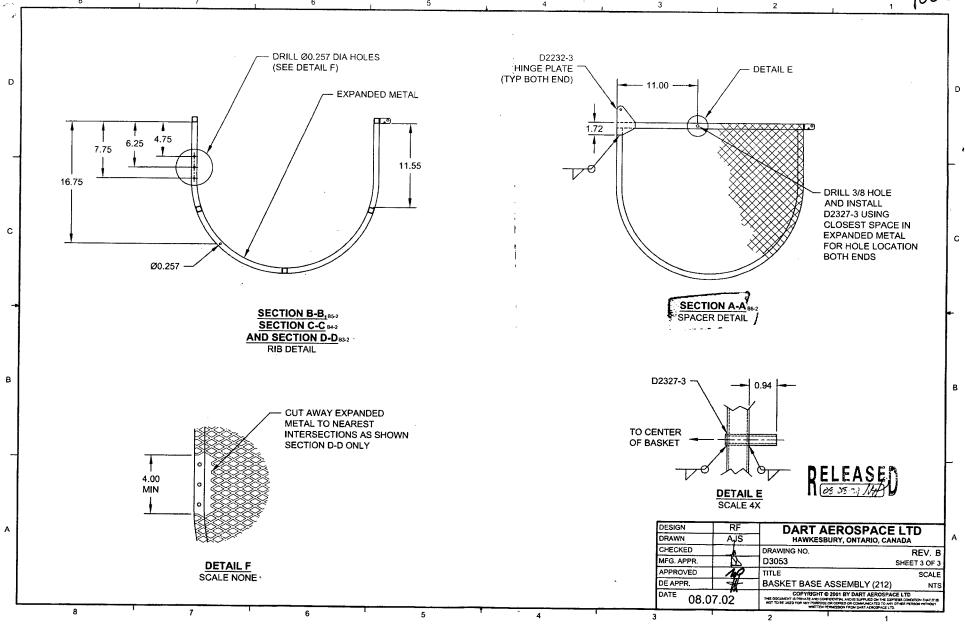
9) CUT LENGTH/SHAPE PER DIAGRAM ANÚ PARTS LIST 10) WELD PER DART QSI 004

В	UPDA1	TED. DRAWIN	WAS 0.060 WALL. MESH MATERIAL IG MOVED TO "B" FORMAT AND RENT STANDARDS.	AJS	08.07.02				
A	NEW I	SSUE		RF	01.11.01				
REV.			DESCRIPTION	BY	DATE				
DESIGN		RF	DART AEROSP	ACF	LTD				
DRAWN		AJS	HAWKESBURY, ONTAR						
CHECKE	D		DRAWING NO.		REV. B				
MFG. AF	PR.	77	D3053		SHEET 1 OF 3				
APPRO\	/ED	149	TITLE		SCALE				
DE APPE	₹.	-#-	BASKET BASE ASSEMBLY (212) NTS						
DATE	08.0	7.02	COPYRIGHT © 2001 BY DART A THIS DOCUMENT IS THINKITE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNIC.	ON THE EYES	Eta COMPETION THAT IT IS				

DQA:			Date:										<b>™</b> ∆APT	
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only								
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Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	-				<del></del>	Rework			Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	٧o.	·			<del></del>	Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is	1	Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR N	۷o. <sub>-</sub>					Suspected Unapproved			Large Fab	Composite	]	Supplier		
Root		_			Desc	ription of work order update		Initial	Actio	n	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cł	nief Eng	Descrip	tion	Date	Verification	QC Inspector	
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Doc/Data														
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Landir						<b>General</b> ™ Bend	_	]:_/c	\		10.4.4.5		1	
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	$\vdash$	Cracks	or concer	·	$\vdash$	Broken/Damage/Defect *	$\vdash$	┪			Over/Under	<del></del>	Set-up	
	$\dashv$	Crimp/Kir	sk/Pinnlo	Mayo	-	Burrs	-	Hardwa		unlified	Part Incorred	<b> </b>	Temperature/Cure	
	$\vdash$	Cuffs	ik/kippie,	/ wave	-		$\vdash$	4	ion Incomplete/Unqu		Part Lost/Mi	ssing –	Weld	
		Crushing			-	Contamination Countersink	$\vdash$	4	tions Incomplete/Uno gned/off center	Liear —	Part Moved	<u> </u>	Wrong Stock Pulled	
	-	Heat Trea	ıt.			Cut Too Short	$\vdash$	Mislabe	='	<b>—</b>	Positioned W Power Loss/	_	Other	
	$\vdash$	Inspection		Tube	-	Drawing	$\vdash$	Misread			I comer ross/:	ourge	Other	
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						Finish	$\vdash$	-						
						Fit/Function	Out of Calibration Out of Sequence							



DQA:		Date:			<u>.</u>									
QA Closed: Date:					WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only									
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					Rework			Skid-tube Crosstube	e[		Water Jet	Engineering		
Part No	0				Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality		
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<u> </u> -	Cracks			-	Broken/Damage/Defect	H	Grain			Over/Under tolerance Part Incorrect Part Lost/Missing		Temperature/Cure		
-	<b>⊣</b>	Crimp/Kink/Ripple/Wave Burrs			$\vdash$	Hardware Inspection Incomplete/Unqualified		$\vdash$	Weld					
-	Cuffs			Contamination		1	ions Incomplete/Unclear	$\vdash$	Part Moved		Wrong Stock Pulled			
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				<u> </u>	Broken/Damage/Defect	_	Hardware			Part Incorre	j	→ .	emperature/Cure	
	Crimp/Kink/Ripple/Wave			<u> </u>	Burrs	<u> </u>	Inspection Incomplete/Unqualified			Part Lost/Missing			eld	
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,	Crushing					Countersink	<u> </u>	Misaligned/off center			Positioned Wrong			
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. ~	Inspection Strip in Tube				<u> </u>	Drawing	<u> </u>	Misread						<u>-</u> -
	Marks/Chatter				<u> </u>	Drill Holes	<u> </u>	Off-set				<del> </del>		
·	-	Turning S			<u> </u>	Finish	_	Out of Calibration						
Wave/Twist in Tube				e	ı	Fit/Function	l	Out of 9	Sequence					